\*October-05-12 9:10:09 AM Item ID: D350-567-031 Accept \*N900040100\* Setup Start Revision ID: **Item Name:** Interior Floor Window (Sliding Door Compatible) Start Date: 04/10/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 19/10/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Date://// Tooling: Approvals: Date: \_\_\_\_\_ Stop **SPC (Y/N):** QC: Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Reject Reject Accept Insp. Work Center ID Description Qty **Run Hours** Code Qty Number Stamp Draw Nbr **Revision Nbr** N/A Rev D 100 hAbel while DOCUMENT CONTROL \*100\* DC Memo Document Control Photocopy blue file and create labels per PPP D350-567-031 chg001 110 0.00 Packaging \*110\* Packaging 0.00 Memo Packaging Pick Packing Kit \*\*\*ENSURE DT 8439 TEMPLATE IS INCLUDED\*\*\* QC4-100% Inspect kits for completeness 120 \*120\* Memo Quality Control

											DQA:	Date	e:	`
NCR:	⁄es	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UPE		QA Closed:	Date		, *
									···		***************************************		<del> </del>	
Work Orde	er:					DISPOSITION			AGAINST DEPARTMENT/PROCESS					·
Part N	Part No					Rework Skid-tube Crosstube  Scrap Machining Small Fab  Use-as-is Thermoforming Finishing  Work Order Update Large Fab Composite		Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
D						ption of work order update		nitial	Act	ion	Sign &			
Root Cause	İ	Date	Step	Qty		or Non-conformance	ı	ief Eng		iption	Date	Verification		QC Inspector
Doc/Data	$\vdash$	Date	Step	Qty		Non comormance		iici ciigi	Desci	iption	Date	Vermeation	+	QC IIISPECTO!
	-													
Equip/Tooling	$\dashv$						Į							
Operator	$\dashv$													
Material	Н		ļ								i			
Setup	Н													
Other	Н							-						
Process Supplier	Н											:		
Training	Н													
Unapproved	H													
опаррточеа			<u> </u>	i	l	F	AUL	T CATE	GORY		l	1		· · · · · · · · · · · · · · · · · · ·
Landi	ng G	ear				General							-	
		Bending				Bend		Grain			Ovalized		Pi	ressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	T	emperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	F	$\neg$ <sub>v</sub>	/eld
	$\boldsymbol{\vdash}$	Crushed/	Crimped,			Burrs		4	ions Incomplete/U	Jnclear	Part Lost/M	<b>+</b>	$\neg$	/rong Stock Pulled
	$\vdash$	Cuffs	•			Contamination		Mainte	•		Part Moved			-
	-	Heat Trea	ıt			Countersink		Mislabe	eled		Positioned \			
	П	Inspection	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss,		По	ther
	Ripples in Bend					Drill Holes		Offset			-			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-05-12 9:10:09 AM Îtem ID: D350-567-031 Revision ID: Item Name: Interior Floor Window (Sliding Door Compatible) **Start Date:** 04/10/2012 **Required Date:** 19/10/2012 **Reg'd Oty:** 1.00 Reference:

Accept

\*N900040100\*

Setup Start

Start Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Approvals:

Process Plan: Date:

Tooling:

0.00

0.00

Date:

Run

Reject

Qty

Accept

Qty

Insp.

Stamp

\_\_\_\_ Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Tool # Plan

Code

Stop

Reject

Number

Sequence ID/ Work Center ID

130

\*130\*

Packaging Packaging

Packaging

Operation

Description

Memo

Identify and pack for shipping as per PPP D350-567-031

Location:

PPP Rev:

QC21- Final Inspection - Work Order Release

140

QC Quality Control

Memo

0.00

0.00

											DQA:	Date:	4
NCR:	res /	No				WORK ORDER NON-	CON	NFORN	/IANCE / UPI		QA Closed:	· Date:	, 3
						DISPOSITION				AGAINST DE		· · · · · · · · · · · · · · · · · · ·	•
Work Orde	er:					Rework	٦		Skid-tube	Crosstube	1	Engineering	
Part N	No.					1 <u></u> 1			Small Fab	Pro	Water Jet d. Eng. Coor.	Quality	
						Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No.						Work Order Update	]		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	D	ate	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling									İ				
Operator									I				
Material	Ш						1		İ				
Setup (	Ш	,											
Other													
Process	Ш												
Supplier													
Training								:					
Unapproved					<u> </u>				_		<u></u>		
		<b></b> .					AUL	T CATE	GORY	<del></del>			
Landi	ng Gear					General	_	1			7	_	٦
	—	ding				Bend		Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S			ntric to	o/s	BOM/Route		Hardwa			Over/Under	<u> </u>	Temperature/Cure
	Cracks				Broken/Damaged		4 `	ion Incomplete		Part Incorre		Weld	
	Crushed/Crimped.				L	Burrs		4	ions Incomplete/	Unclear	Part Lost/M		Wrong Stock Pulled
	Cuf	fs			L	Contamination	L	Mainte	nance		Part Moved		
	Hea	it Trea	t			Countersink		Mislabe	led		Positioned	7	
	Inspection Strip in Tube Cut Too Sho				Cut Too Short		Misread	1		Power Loss	/Surge	Other	

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

## **Picklist Print**

October-05-12 9:10:13 AM

Work Order ID: 91330

\*91330\*

Farent Item:

Parent Item: D350-567-031 \*D350-567-031\*
Parent Item Name: Interior Floor Window (Sliding Door Compatible)

79478

83542

**Start Date:** 04/10/2012

Required Date: 19/10/2012

Start Qty: 1.00

Required Oty: 1.00

Comments:

IPP Rev: A new issue 08-04-25 DD verified by: LL

	IPP Rev:B 08-10-				2.12								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C632R12 *AN526C Screw	632R12*	Purchased	No	9 1888 <del></del>		120	Each	129.0000	**	8	δP		
				Location	Į.	Loc (	<u>Qty</u>	Loc Code					
				ST344			28						
					122378		28				_		
				ST345			100				_		
					122814		100		_	82			
				ST347			1				_		
					119225		1		_		_		
D2463		Manufactured	No			120	f	821.6981	3.75	3.75			
*D2463*									**		Sp		
Seal				Location		Loc (	Qty	Loc Code	•				
				ST402			500						
					90297		500		_		-		
				ST404		321.69	807		-		-		
9	oxel				72232		5.38		-		_		

(D2463-0450) CUT (1) AT 45.00" ASPER DWG

Manufactured No 120

0.43737

305.8807

Each

0.0000

B91696 D B-11-16.

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
											QA Closed:	Date:	
Work Orde	<b>.</b> r.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	•
	•					Rework		Skid-tube Crosstube			_	Water Jet	Engineering
Part f	١٥.					Scrap	1		Machining	Small Fab	1	d. Eng. Coor.	Quality
NCR No.				<del></del>	Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other	
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data					·								
Equip/Tooling													
Operator													
Material													
Setup	_												
Other								i					
Process							1						
Supplier Training													
Unapproved													<u> </u>
						F	AUI	T CATE	GORY				
Landi	ng (	Gear				General		_			-	_	7
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route	_	Hardwa			Over/Under	<del></del>	Temperature/Cure
	_	Cracks			_	Broken/Damaged	_	<b>-</b> 1 '	ion Incomplete		Part Incorre	<del>                                     </del>	Weld
	_	Crushed/	Crimped.		<u> </u>	Burrs		-	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	_	Cuffs				Contamination	_	Mainte		_	Part Moved		de) ·
	<u> </u>	Heat Trea			_	Countersink	$\vdash$	Mislabe		_	Positioned V		٦٠٠٠
	_	Inspectio	•	Tube	<u> </u>	Cut Too Short	$\vdash$	Misread	d	L	Power Loss/	Surge	Other
	-	Ripples in			<u> </u>	Drill Holes	$\vdash$	Offset	California i				
	<u> </u>	Torque W			n	Drawing	-	Out of Calibration					
	Turning Sequence			Finish		Jout of S	Sequence						

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

#### **Picklist Print**

October-05-12 9:10:13 AM

Work Order ID: 91330

\*91330\*

Parent Item: D350-567-031 \*D350-567-031 \*Parent Item Name: Interior Floor Window (Sliding Door Compatible)

**Start Date:** 04/10/2012 Start Qty: 1.00

**Required Date: 19/10/2012** 

Required Qty: 1.00

D3211-1

Manufactured

120

Each

3.0000 \*\*

D3212-1 Floor Window

Manufactured No Location Loc Qty ST211 3 79310 81495 2 120 Each

7.0000

Loc Code

\*\*

Door Assembly

Manufactured

Location Loc Qty ST210 7 81496 120 Each

4.0000

Loc Code



DT8439

Manufactured No

Location

90815

ST211

4 120 Each

Loc Qty

0.0000

Loc Code

\*\*

template

No Purchased

120 Each

Rivet, Universal Head

Location	Loc Qty	Loc Code
334	1410	
122452	1410	
ST319	554	
118405	253	
120143	301	

40x

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											••		
									·		QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	<b>«</b>
	Part No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								·					
				•		F	AUI	T CATE	GORY				
Landi					<u> </u>	General		1		_	7	<u></u>	¬
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs		Bend BOM/Route Broken/Damaged Burrs Contamination	Har Inst		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled			
	Heat Treat			Countersink		Mislabe	eled		Positioned \	Wrong	Journal		
	Inspection Strip in Tube Cut Too Sho Ripples in Bend Drill Holes		Cut Too Short Drill Holes	$\vdash$	Misread Offset	d ()		Power Loss,	Surge	Other			
				Drawing		Out of	Calibration						
	Turning Sequence			Finish		Out of	Sequence						

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

October-05-12 9:10:13 AM

Work Order ID: 91330

\*91330\*

MS20470AD4-6

Parent Item: D350-567-031 \*D350-567-031\*

Parent Item Name: Interior Floor Window (Sliding Door Compatible)

Start Date: 04/10/2012

**Required Date: 19/10/2012** 

Start Qty: 1.00

Required Qty: 1.00

Purchased

No

120

Each 5,100.000

Loc Code

Loc Code

\*\*

Location	Lo	c Qty
336		1500
122452		1500
ST319		600
117395		16
118927		157
119109		12
120142		81
121524		334
ST336		3000
123021		3000
	120	Each

90 K 1,841.000

MS20470AD4-7

Purchased

No

Sp 12-11-16.

Rivet, Universal Head

Location	Loc Qty
336	1300
122452	1300
ST139	224
121415	224
ST319	52
120769	52
ST320	265
116081	117
118614	148

_	201	۷

										DQA:	Date:	
NCR:	'es / N	0			WORK ORDER NON-O	CONFC	ORN	AANCE / UPDATE		QA Closed:	Date:	•
		<u> </u>			DISPOSITION	Ī		AGAINS	T DE	PARTMENT		•
Work Orde	er:				1	1		Skid-tube Crosstube		Water Jet		Engineering
Part N	No				Rework Scrap Use-as-is	Machining Small Fab Thermoforming Finishing		b	Prod. Eng. Coor.  Rec/Store/Packaging		Quality	
NCR No.					Work Order Update Large Fab Composite			e				
Root				Descri	ption of work order update	Initia	al	Action		Sign &		
Cause	Dat	e Step	Qty		or Non-conformance	Chief I	Eng	Description		Date	Verification	QC Inspector
Doc/Data							1					
Equip/Tooling												
Operator		1										
Material						İ						
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
					F	AULT C	ATE	GORY				
Landi	ng Gear				General				<u></u>	-		_
Bending					Bend	Gra	ain		L	Ovalized	[	Pressure/Forced
	Centre Not Concentric to O/S BOM/Route				BOM/Route	Har	dwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Damaged					Inst	pecti	on Incomplete		Part Incorre	ct	Weld
Crushed/Crimped. Burrs					Burrs	Inst	tructi	ions Incomplete/Unclear		Part Lost/M	ssing	Wrong Stock Pulled
	Cuffs Contamination					Ma	inte	nance		Part Moved		
	Heat Treat Countersink				Mis	slabe	led		Positioned V	_		
	Inspection Strip in Tube Cut Too Short				Mis	Misread			Power Loss/	Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

### **Picklist Print**

October-05-12 9:10:13 AM

Work Order ID: 91330

\*91330\*

Parent Item: D350-567-031 \*D350-567-031\*

Parent Item Name: Interior Floor Window (Sliding Door Compatible)

Purchased

No

**Start Date:** 04/10/2012

**Required Date:** 19/10/2012

Start Qty: 1.00

Required Qty: 1.00

M <u>\$2</u>	1042L06			
		4n4	21 (	า6*
Nut	.,			

Location	<u>n</u>	
315		
	122441	
ST317		
	122151	
		120

Loc Code Each 213.0000

Loc Code

429.0000







Location Loc Qty 298 196 122441 196 ST298 17 118428 17

120

Each

Loc Qty

NCR: Y	es / N	lo			WORK ORDER NON-O	CONF	ORN	MANCE / UP	DATE			
										QA Closed:	Date	:
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS  Skid-tube Crosstube Water Jet Enginee						
Part N	-				Rework Scrap Use-as-is Work Order Update	]     	Machining Small Fab Thermoforming Finishing		Crosstube Small Fab Finishing Composite	Pro Rec/Stor	Engineering Quality Other	
Root				Descri	ption of work order update	Init	tial	Ac	tion	Sign &		
Cause	Da	e Step	Qty	ł	or Non-conformance	Chief	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other		`.						ļ				
Process						ļ						
Supplier												
Training											i	
Unapproved				<u> </u>				<u> </u>				
						AULT (	CATE	GORY				
Landi	ng Gear			_	General					٦	Г-	7. /-
	Bend	-			Bend	—	rain		-	Ovalized	_	Pressure/Forced
	$\vdash$	e Not Conc	entric to	0/5	BOM/Route	<b>  </b>	Hardware			Over/Under tolerance		Temperature/Cure
	Crack			-	Broken/Damaged	—		ion Incomplete	// · · · · · · · · · · · · · · · · · ·	Part Incorre	<del> </del>	Weld
	_	ed/Crimpe	a.	$\vdash$	Burrs			ions Incomplete/	Unclear	Part Lost/M	ssing	Wrong Stock Pulled
	Cuffs	Tunnt		-	Countaring	$\boldsymbol{\vdash}$	Maintenance Mislabeled			Part Moved	Mrang	
	Heat		in Tubo	-	Countersink Cut Too Short	<b>├</b> ─┤	Misread			Positioned V Power Loss/		Other
		ction Strip i es in Bend	m rube	-	Drill Holes		iisread ffset	u	L	Trower ross/	ourge [	Tomer
	_	es in Bend ie Waves in	Evtrucio	<u> </u>	Drawing	$\vdash$		Calibration		· · · · · · · · · · · · · · · · · · ·		
		ng Sequenc		"'	Finish	$\vdash$		Sequence				
	l liuini	ng acqueill	·C	1	h 1111211	1 10	ut OI 3	equence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

# DART AEROSPACE LTD.



D350-567 Page 28 of 28



#### 5.0 **PARTS LIST**

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X	3017	-020	-021			D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	х					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		Х				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				Х		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					Х	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
<u> </u>	<u> </u>	1	1		-	D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

		<del></del>				
Qty	Qty	Qty	Qty	_Qty <sub>7</sub>		
-013	-023	-113	-115	<b>4</b> -03,1	Part Number	Description
X				V.	D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		Х			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			Х		D350-567-115	INTERIOR FLOOR WINDOW KIT
				Х	D350-567-031	INTERIOR FLOOR WINDOW KIT
						(SLIDING DOOR COMPATABLE)
					D2125	REPLACEMENT WINDOW, SMALL
11						
	1				D2942	REPLACEMENT WINDOW, LARGE
	ļ	1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
<b></b>	1				D2463-0750	NEOPRENE SEAL
<b></b>	•	1		<u> </u>	D2463-0860	NEOPRENE SEAL
	9	12		·	2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21		<del></del>	AN526C832R9	SCREW (OR AN526C832-9.OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ.	2 SQ.	2 SQ.			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
YD	YD	YD				
			ļ	71-	-D2463-0450	NEOPRENE SEAL
				(1	D3210-1	DOUBLER
				7 1	D3214=1=	-BRACKET
				1	D3212-1/	FLOOR WINDOW
				11	D3213-041	1DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	-NEOPRENE SEAL
			9	/8	AN526C632R12-	-SCREW (OR AN526C632-12, OR MS51957-32)
			9	<i>)</i> 8	AN960JD6	, WASHER
			9	7 8	MS21042L06	NUT (OR MS21042-06)
			2	740	MS20470AD4-5	RIVET
			115	/ 90	MS20470AD4-6	RIVET
	Ī	I	15	`7,20	MS20470AD4-7	RIVET

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Revision: D

Date: 08.07.08